

Work Order ID 72028

Monday, July 18, 2011 9:57:08 AM



Page 1

Item ID:	D3443-041	Accept		Setup	Start				
Revision ID:									
Item Name:	Strut Weldment Assembly				Stop				
Start Date:	7/18/2011	Start Qty: 3.00		Cust Item ID:					
Required Date:	7/25/2011	Req'd Qty: 3.00		Customer:					
Reference:									
Approvals:	Process Plan:	Date: 107-18	Tooling:	Date:	Run	Start			
	QC:	Date:	SPC (Y/N):	Date:	Stop				
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3443	Rev C								
100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld assembly as per dwg D3443								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	Memo	0.00							
QC									
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
QC									
Quality Control									

S wlos 17

PL 118-16

P 08-17

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3443-041

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Setup Start



Revision ID:

Item Name: Strut Weldment Assembly

Stop



Start Date: 7/18/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Powdercoat

Powder Coating

Memo

1-Mask holes as per dwg D3443

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:30⁰⁰
400^{0F}
10:00

4X Ø m/l 11/08/14

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

4 Ø M/L 11/08/14

150



Small Fab

Small Fab

0.00

8/11/08/22 ④

Small Fab

Memo

0.00

Assemble bearing and ball plungers as per dwg D3443 using DT9518

Ensure bearing rotates smoothly

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Item Name: Strut Weldment Assembly

Stop



Start Date: 7/18/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

160



QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

S u l o s l z z

(F4)

170



Packaging

Packaging

Identify as per dwg & Stock Location: G-A 0.00
Memo w/o 71987 (2x) 0.00
 w/o 71989 (2x) 0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release 0.00
Memo 0.00

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NOTE: Date & initial all entries

Picklist Print

Monday, July 18, 2011 9:57:15 AM

Page 1

Work Order ID: 72028



Parent Item: D3443-041



Parent Item Name: Strut Weldment Assembly

Start Date: 7/18/2011

Required Date: 7/25/2011

Comments: IPP REV. A 05.11.17 NEW ISSUE ECR

Start Qty: 3.00

Required Qty: 3.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Monday, July 18, 2011 9:57:15 AM

Page 2

Work Order ID: 72028



Parent Item: D3443-041



Parent Item Name: Strut Weldment Assembly

Start Date: 7/18/2011

Required Date: 7/25/2011

Start Qty: 3.00

Required Qty: 3.00

D3966-4-750



Manufactured No

100

Each

32.0000

2

6



Pin, Dowel

EL 11-8-16

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST100 58711	32 32	8

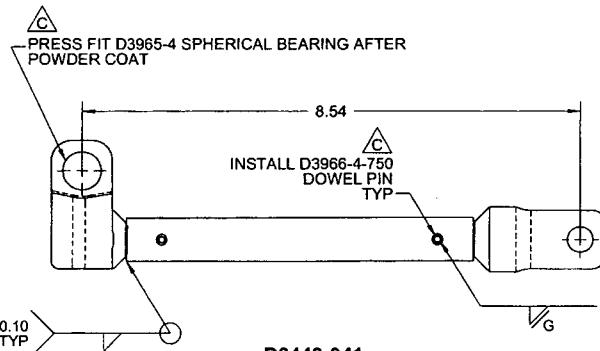
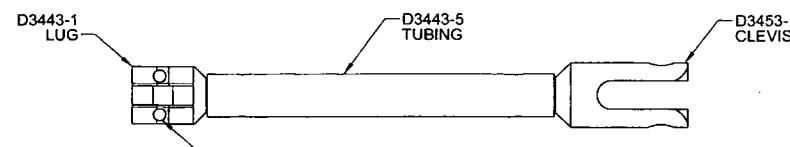
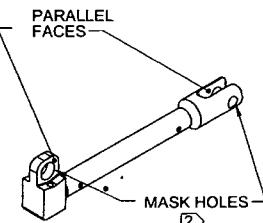
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ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72028
PL 110718

RELEASED
09/08/2018

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.33 lbs
- 8) WELD PER DART QSI 004

REV.	DESCRIPTION	BY	DATE
C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE J2 (ZN A8-1, A8-2): 0.820 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3). 0.551 WAS 0.451 (ZN C1-3). R0.219 WAS R0.050 (ZN C4-3); D3965-4 WAS SPAENAUER PN (ZN C6-1, BS-3). D3966-4-750 WAS MCMASTER-CARR P/N (ZN B5-1). REF PAR 09-018	RF	09.06.25
B	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & 0.0125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3443	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STRUT WELDMENT ASSEMBLY	NTS
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

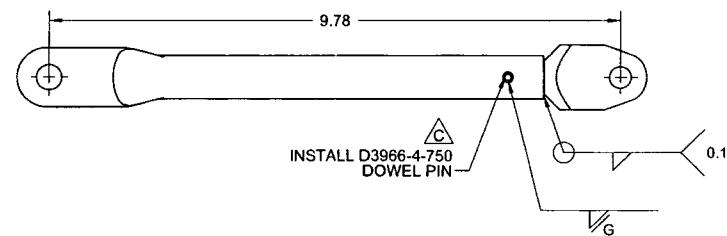
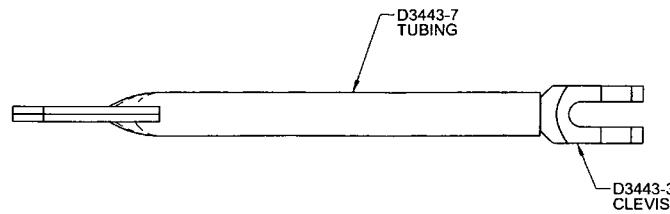
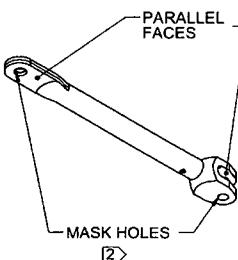
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ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN



72028

RELEASED
09/08/25/14

D3443-043

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs
- 8) WELD PER DART QSI 004

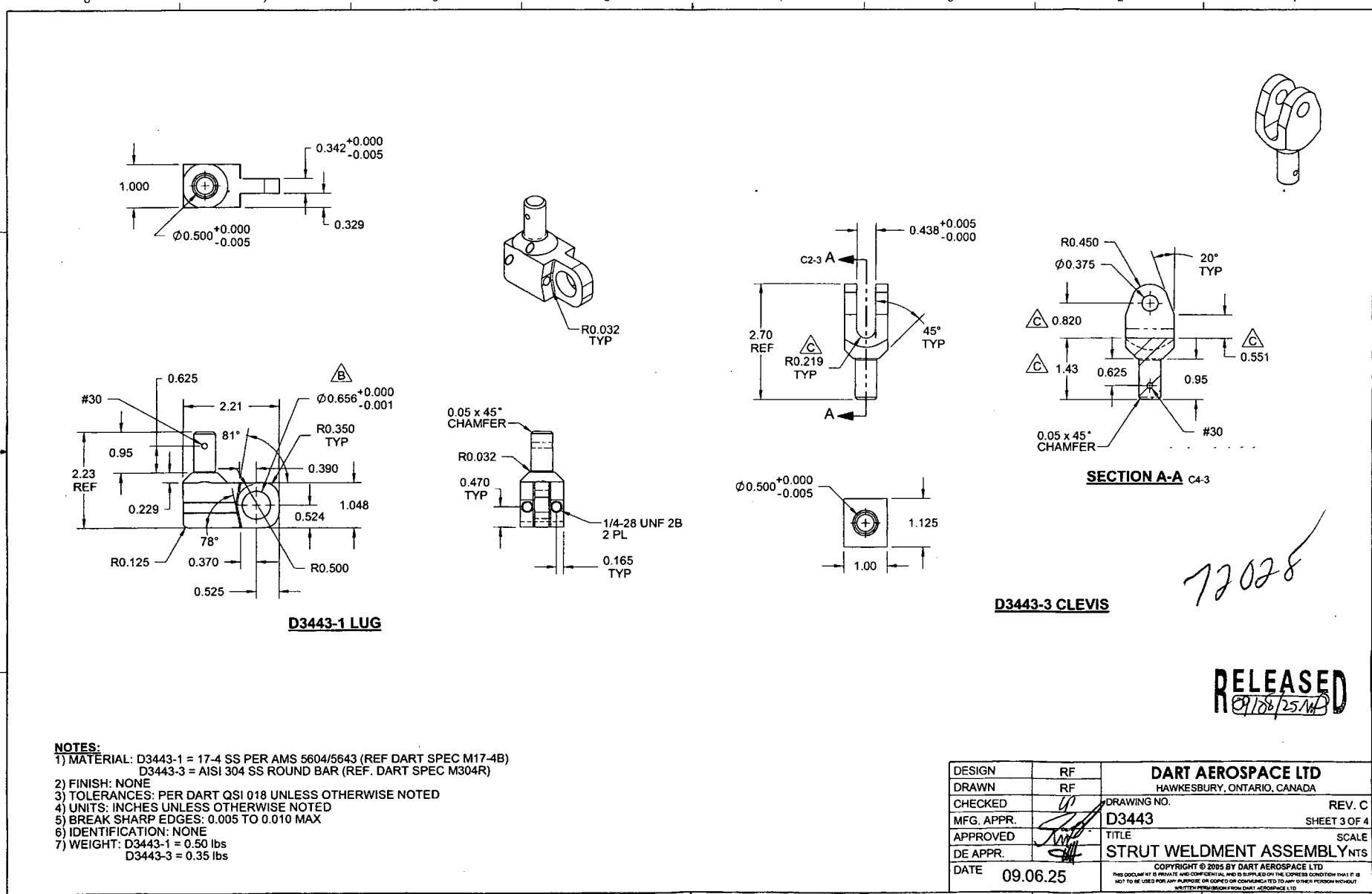
DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	✓	DRAWING NO. REV. C
MFG. APPR.		D3443 SHEET 2 OF 4
APPROVED	✓	TITLE SCALE
DE APPR.	✓	STRUT WELDMENT ASSEMBLY NTS
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS RESTRICTED FROM REPRODUCTION OR COMMUNICATION OUTSIDE DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

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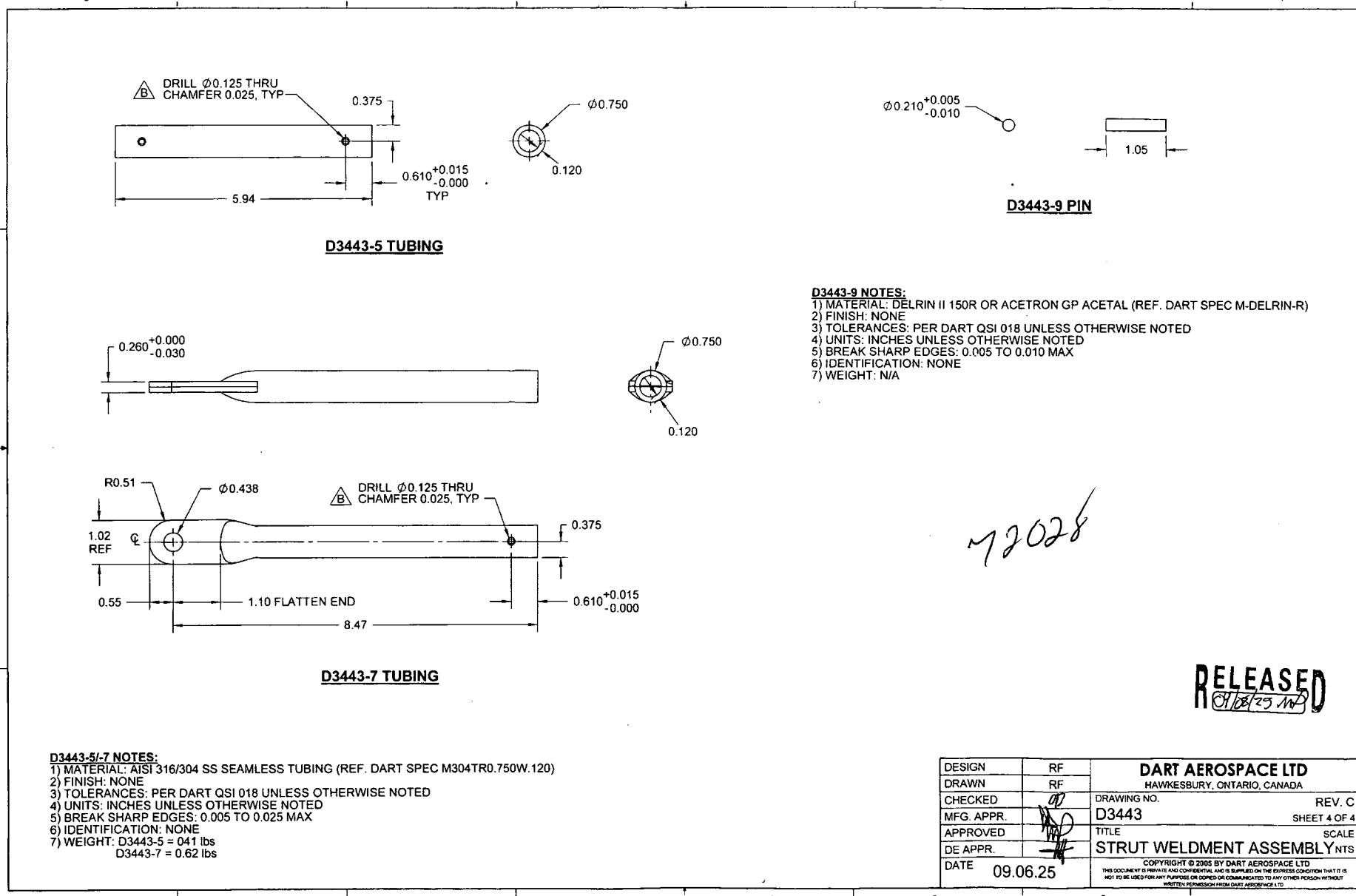


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